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D2739
Job Sheet 184894



Part No: D2739

Job Qty: 10 ea

Part Name: 350 I-Beam



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/17/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D2739 REV E IPP Rev: C 02.11.28 Reformat KJ IPP Rev: D 06-03-21 As Per Rev C JLM IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev:F 10.11.02 as per revE DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard			Workcenter/Supplier			Sign-off
					Setup Hrs	Run Hrs		Workcenter / Supplier	Lead Time		
90	Start up Operation	10 Ea	11/9/18	11/9/18	0.00	0.00		Start Up Skidtubes-2			TF
100	Skidtubes	10 pcs	11/9/18	11/9/18	0.00	5.41		Skidtubes-3			
120	HandFinish	10 pcs	11/9/18	11/9/18	0.00	0.83		HandFinish1			D.R. 18/10/24
130	QC	10 pcs	11/9/18	11/9/18	0.00	0.00		QC5			
140	Packaging	10 pcs	11/9/18	11/9/18	0.00	0.00		Packaging3-1			OCT 25 2018
150	QC21-SA	10 Ea	11/9/18	11/9/18	0.00	0.00		QC21			

Part Op 100 - 1-Cut D2600-5 to length as per Dwg D2739. 2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739
Descriptions: 3-Use uni-bit to open holes to finish size as per Dwg D2739. 4-Bevel Fwd end of extrusion and Deburr holes and ends.
140 - LOCATION : LG002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-5-108	Extrusion I-Beam Thin	10 Ea (1 ea)	90-Start up Operation	0145248

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2600-5-108	10	28	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Web	78.760Inches ± 0.030	78.790 78.730		
2	Web	1.180Inches ± 0.010	1.190 1.170		
3	Web	3.150Inches ± 0.010	3.160 3.140		
4	Web	1.180Inches ± 0.010	1.190 1.170		
5	Web	0.250Inches ± 0.030	0.280 0.220		
6	Web	30.000Degrees	30.500	Angle	

		+ 0.500 - 5.000	25.000
7	Web	1.250Inches ± 0.030	1.280 1.220
8	Web	7.880Inches ± 0.030	7.910 7.850
9	Web	10.070Inches ± 0.030	10.100 10.040
10	Web	12.990Inches ± 0.030	13.020 12.960
11	Web	16.540Inches ± 0.030	16.570 16.510
12	Web	20.870Inches ± 0.030	20.900 20.840
13	Web	25.200Inches ± 0.030	25.230 25.170
14	Web	29.530Inches ± 0.030	29.560 29.500
15	Web	32.650Inches ± 0.030	32.680 32.620
16	Web	33.860Inches ± 0.030	33.890 33.830
17	Web	35.350Inches ± 0.030	35.380 35.320
18	Web	38.280Inches ± 0.030	38.310 38.250
19	Web	41.350Inches ± 0.030	41.380 41.320
20	Web	44.350Inches ± 0.030	44.380 44.320
21	Web	47.400Inches ± 0.030	47.430 47.370
22	Web	50.150Inches ± 0.030	50.180 50.120
23	Web	52.900Inches ± 0.030	52.930 52.870
24	Web	64.060Inches ± 0.030	64.090 64.030
25	Web	70.270Inches ± 0.030	70.300 70.240
26	Web	73.020Inches ± 0.030	73.050 72.990
27	Web	75.770Inches ± 0.030	75.800 75.740
28	Web	56.150Inches ± 0.030	56.180 56.120

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER: _____							
Misidentified ☐	Past Due ☐								